

NOTES

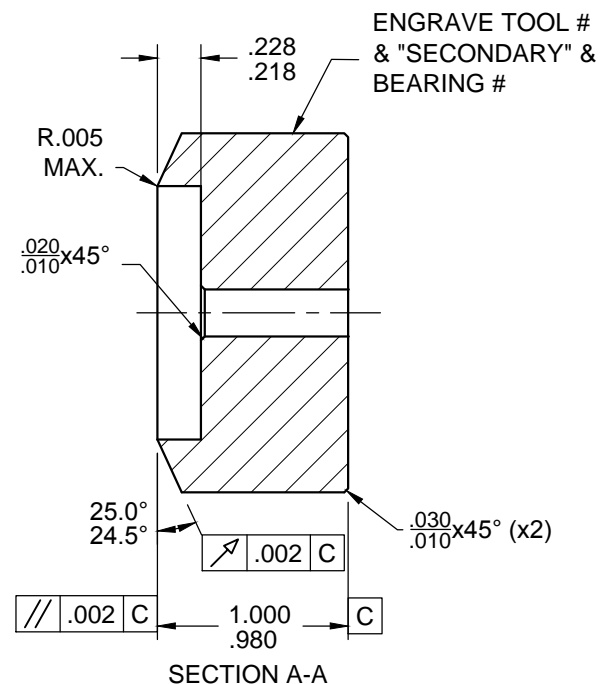
1. BREAK ALL SHARP CORNERS (.015/.03).

UNDER REVIEW

URF 19-1110 19.10.30 (VM)


TOOL #	ØA	PIN	MATERIAL
KST-BACB10AB	+000 -002	TYPE	
KSTAB04	.248	I	1018 RND. BAR Ø5/16 x 5/8

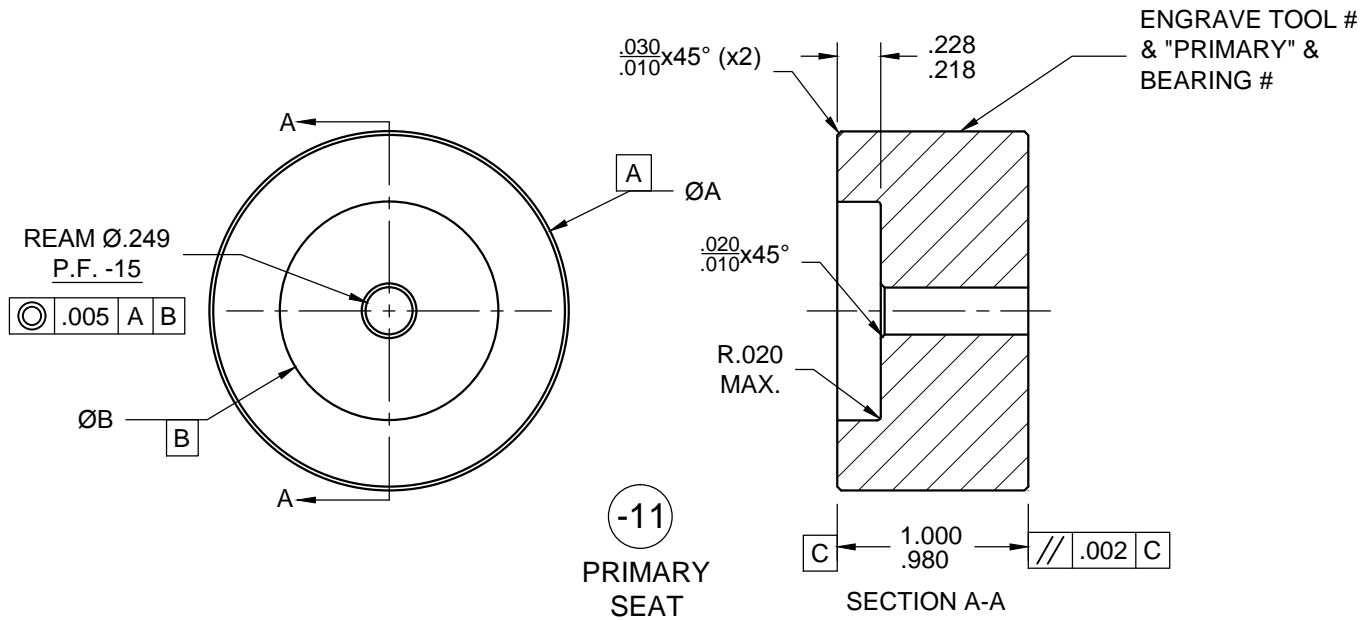
RED BARN MACHINE			
TITLE KSTAB SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10AB BEARINGS			
DWG NO.	(TOOL#) -15 LOCATING PIN		REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT	
XXX ± .005		FINISH	
XX ± .01		SPEC	
X ± .1		BLACK OXIDE	
UNLESS OTHERWISE SPECIFIED		USED ON BEARING	
1. BREAK ALL SHARP EDGES		SEE Pg. 1	
.015 x 45° PR .015 R			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	9-23-08
		SHEET	9 of 9



UNDER REVIEW

- URF 19-1110 19.10.30 (VM)

 RED BARN MACHINE	
TITLE KSTAB SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10AB BEARINGS	
DWG NO. (TOOL#) -13 SECONDARY SEAT	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED _____ HEAT TREAT _____ FINISH SPEC BLACK OXIDE _____ USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-23-98
	SHEET 8 of 9



TOOL #	ØA	ØB	MATERIAL
KST-BACB10AB	$\begin{smallmatrix} +.020 \\ -.020 \end{smallmatrix}$	$\begin{smallmatrix} +.000 \\ -.005 \end{smallmatrix}$	
KSTAB04	.875	.500	4140 Q&T RND. BAR Ø7/8 x 1-1/8

- NOTES**
- BREAK ALL SHARP CORNERS (.015/.03).


UNDER REVIEW
URF 19-1110 19.10.30 (VM)

RED BARN MACHINE	
TITLE KSTAB SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10AB BEARINGS	
DWG NO. (TOOL#) -11 PRIMARY SEAT	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-23-08 SHEET 7 of 9



NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE KSTAB SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10AB BEARINGS	
DWG NO. (TOOL#) -9 PIN	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-23-98
	SHEET 6 of 9



UNDER REVIEW
URF 19-1110 19.10.30 (VM)



RED BARN MACHINE

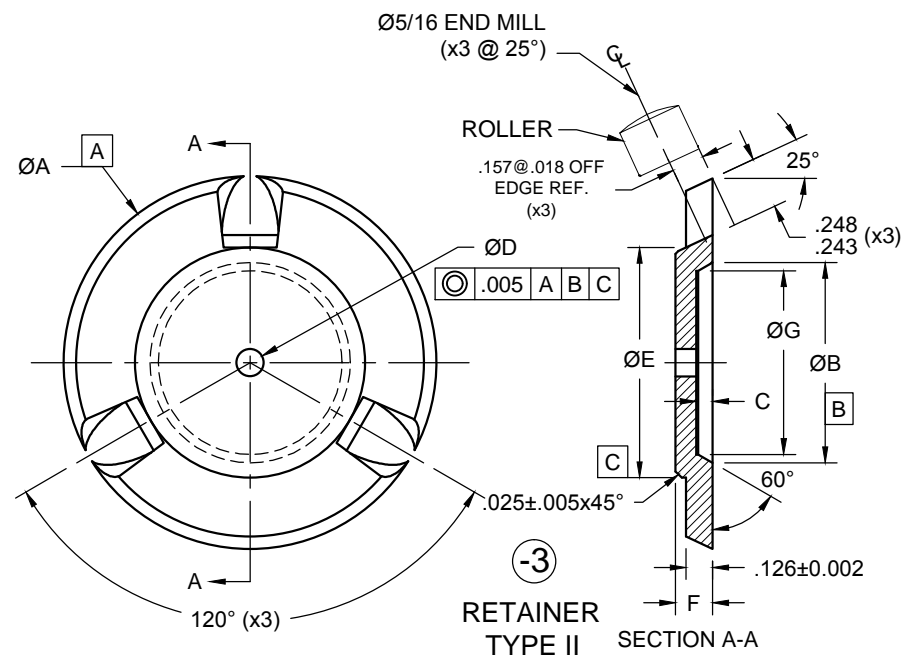
TITLE	KSTAB SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10AB BEARINGS
-------	---

DWG NO.	(TOOL#) -5 ROLLER (QTY. 3)	RE
---------	----------------------------	----

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT
	APPROVED
	HEAT
	TREAT
	FINISH SPEC


UNLESS OTHERWISE SPECIFIED	USED ON BEARING
1. BREAK ALL SHARP EDGES	SEE Pg. 1
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	

SCALE	NTS	DATE	9-23-08	SHEET	4 of 9
-------	-----	------	---------	-------	--------

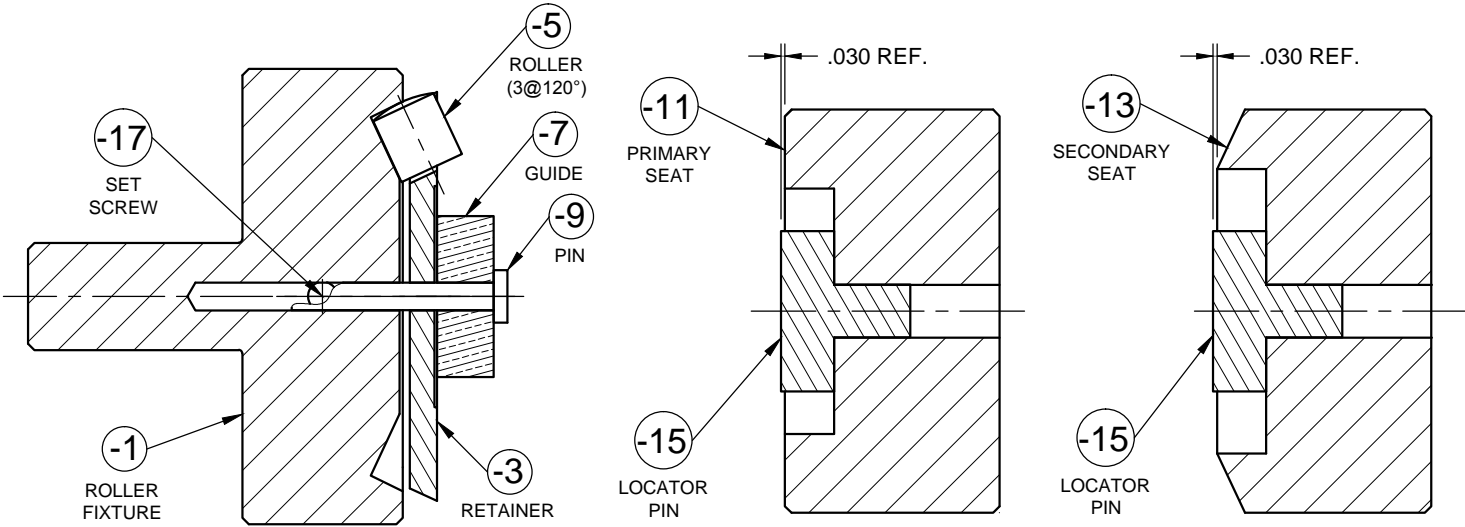
[illegible]

URF 19-1110 19.10.30 (VM)

1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE KSTAB SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10AB BEARINGS	
DWG NO. (TOOL#) -3·RETAINER	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING SEE Pg. 1
SCALE NTS	DATE 9-23-98
SHEET 3 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
-	-	-	-	-



UNDER REVIEW
URF 19-1110 19.10.30 (VM)

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
BACB10AB04	KSTAB04

- NOTES**
- 1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
 - 2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
 - 3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	1	SECONDARY SEAT	SEE CHART	8
		-15	2	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RED BARN MACHINE

TITLE

KSTAB SERIES DP TRI-ROLLER SWAGING TOOLS FOR BACB10AB BEARINGS

DWG NO.

(SEE TOOL# ABOVE); ASSEMBLY

REV

-

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XX ± .01
.X ± .1

FRACTIONS ± 1/32
ANGLES ± 5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

DRAWN BY: PERRITT

APPROVED

HEAT TREAT LISTED PER ITEM

FINISH SPEC LISTED PER ITEM

USED ON BEARING

SEE ABOVE

SCALE

NTS

DATE


9-23-08

SHEET

1 of 9

[illegible]

URF 19-1110 19.10.30 (VM)


 RED BARN MACHINE			
TITLE			
DWG NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE	NTS	DATE	8-15-07
		SHEET	1 of 1

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

UNDER REVIEW
URF 19-1110 19.10.30 (VM)

	PART #	QTY	DESCRIPTION
	-1	1	--

DRAWN BY: PERRITT	 RED BARN MACHINE		
CHECKED			
HEAT TREAT FINISH SPEC			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1			
USED ON MODEL ?	TITLE	TITLE	
	DWG NO.	PART #	REV.
	SCALE NTS	DATE 1-28-06	SHEET 1 of 1
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

UNDER REVIEW
URF 19-1110 19.10.30 (VM)

NOTES

- 1. ENGRAVE P/N; CHARACTER HT. .090.
- 2. ENGRAVE 'PRIMARY'
- 3. ENGRAVE 'SECONDARY'

LT #	QTY	DESCRIPTION
1	1	O-1 DRILL ROD Ø2-1/8 x 1-7/8
3	4	BRASS RND Ø2 x 5/16
5	3	O-1 DRILL ROD Ø3/8 x 1/2
7	1	BRASS RND Ø3/4 x 3/8
9	1	1018 RND Ø1/4 x 1-1/8
11	1	1018 RND Ø1-7/8 x 1-1/8
13	1	1018 RND Ø1-7/8 x 1-1/8
15	1	1018 RND Ø3/4 x 3/4

USED ON MODEL
?

DRAWN BY:	PERRITT
APPROVED	
HEAT TREAT	
FINISH SPEC	BLACK OXIDE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± .5°
.X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° R .015 R	

RED BARN MACHINE	
TITLE	
STAKING TOOLS	
DWG NO.	REV
RB ST1016	
SCALE	DATE 1 24 07 SHEET 1 OF 1